

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-000597**Date Inspected:** 03-Oct-2007**Project Name:** SAS Superstructure**OSM Arrival Time:** 1400**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 2300**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

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|------------------------------------|------------------------------|-----------|------------|----------------------------------|------------|-----------|------------|
| CWI Name: | Zhu Zhong Hai & Li Wen Sheng | | | CWI Present: | Yes | No | |
| Inspected CWI report: | Yes | No | N/A | Rod Oven in Use: | Yes | No | N/A |
| Electrode to specification: | Yes | No | N/A | Weld Procedures Followed: | Yes | No | N/A |
| Qualified Welders: | Yes | No | N/A | Verified Joint Fit-up: | Yes | No | N/A |
| Approved Drawings: | Yes | No | N/A | Approved WPS: | Yes | No | N/A |
| | | | | Delayed / Cancelled: | Yes | No | N/A |

Bridge No: 34-0006**Component:** 77 B, D & 114 A**Summary of Items Observed:**

On this date, Caltrans Office of Structural Materials (OSM), Quality Assurance (QA) Inspector, David A. Smith was present for the observations related the following;

Item-1 77 Meter Mock-Up Skin-B Stiffener plates MA3-1 and MA3-3. The Magnetic Particle (MT) test performed at an earlier time disclosed indications which are now being ground out.

Item-2 77 Meter Mock-Up Skin-D Plate P597 is being welded to stiffener plate MP3-1. A rod oven was being utilized to maintain the required temperature of the welding rods THJ 506 prior to welding. The certified welder Chen Ru Yang #66726 was present to perform the welding. Welding parameters recorded by this QA Inspector were, Amps 181 and Volts 25.1. The QC present was Wang Wei and the CWI was Ye Yong Jun and Li Wen Sheng.

Item-3 114 Meter Mock-Up Skin-A Lower Section. Two grind out areas on Stiffener plates MP1002-1 & MP1002-5 were MT tested by a Level II MT technician Qai Xin Xin and was MT/OK. The Caltrans QA Inspector performed an MT test on the grind out areas and found them to be in compliance with the project specifications. Once the MT had been completed the areas were preheated for the repair welding. The certified welder was Jiang Zhou #040261. Welding parameters recorded by this QA Inspector for plate MP1002-1 were, Amps 323, Volts 31, Travel Speed 340 mm/min. and the temperature was 170c and plate MP1002-5 were Amps 308, Volts 31.5, Travel Speed 324.6 mm/min with a Temperature of 170c. The welding procedure used was WPS-345-FCAW-2G(2F)Repair with the welding wire being Supercored 71H, 1.4mm in diameter.

Summary of Conversations:

There were no pertinent conversations pertaining to the project during this shift.

WELDING INSPECTION REPORT

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Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Mazen Wahbeh, (818) 292-0659, who represents the Office of Structural Materials for your project.

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| Inspected By: | Smith,David | Quality Assurance Inspector |
| Reviewed By: | Cochran,Jim | QA Reviewer |
